

Date: Wednesday, 3/26/2008 9:54:49 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : PEDAL ASSEMBLY
Job Number : 38186	
Estimate Number : 11005	
P.O. Number :	Part Number : D412704041
This Issue : 3/26/2008 S.O. No. :	Drawing Number : D412-704-041 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : 37168	Material :
Written By :	Due Date : 4/4/2008 Qty: <u>2</u> Um: Each
Checked & Approved By : <u>JD 08.3.27</u>	
Comment : Est Rev:B 05.01.28 Removed hardware on Step 2; Added Figures 1-3 KJ/RF	
Est Rev:C 06.03.08 Re-format EC	
Est Rev:D 07-03-20 Added Dwg D412-704-041 07-03-20 JLM	
Est Rev:E 07.05.02 Reformat EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D3204041	Pedal Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part number	Description	batch
1	D3204-041	Pedal Assembly	B 37775

SB 08/04/24 (2)

2.0	D32051	Bracket
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part number	Description	batch
1	D3205-1	Bracket	B 35854

SB 08/04/24 (2)

3.0	D32053	Back Plate
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part number	Description	batch
1	D3205-3	GHW Bracket	B35209

SB

4.0	D32061	Pedal Arm
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part number	Description	batch
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8/4/7 SB (2x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

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Drawing Name: PEDAL ASSEMBLY

Job Number: 38186

Part Number: D412704041

Job Number:



Seq. #:

Machine Or Operation:

Description :

1

D3206-1

Pedal arm

5.0

D3209041

Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part number	Description	batch
1	D3209-.041	Bracket	<u>1531170</u>

SP

6.0

AN310A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part number	Description	batch
1	AN3-10A	Bolt	<u>M17564</u>

SP

7.0

AN3154R

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part number	Description	batch
1	AN315-4R	Nut	<u>M17566</u>

SP

8.0

AN410A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part number	Description	batch
1	AN4-10A	Bolt	<u>M105442</u>

SP

9.0

AN412A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty	Part number	Description	batch
2	AN4-12A	Bolt	<u>M105143</u>

8/4/7

SP

(2x)

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Part Number: D412704041

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

AN413A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part number	Description	batch
1	AN4-13A	Bolt	M106993

SP

11.0

AN960JD10

Washer



Comment: Qty.: 5.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty	Part number	Description	batch
5	AN960JD10	Washer	107534 M106552

A Reenter 10 Sur 106552

SP

12.0

AN960JD416

Washer



Comment: Qty.: 11.0000 Each(s)/Unit Total : 44.0000 Each(s)

Pick:

Qty	Part number	Description	batch
11	AN960JD416	Washer	M106780

SP

13.0

AN960JD416L

Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty	Part number	Description	batch
3	AN960JD416L	Washer	M107008

SP

14.0

MS21042L3

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part number	Description	batch
1	MS21042L3	Nut	M106883

SP

15.0

MS21042L4

Nut



Comment: Qty.: 5.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty	Part number	Description	batch
5	MS21042L4	Nut	M106825

8/4/7

SP

(2x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Drawing Name: PEDAL ASSEMBLY

Job Number: 38186

Part Number: D412704041

Job Number:



Seq. #:

Machine Or Operation:

Description :

16.0

MS24694S102

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part number	Description	batch
1	MS24694S102	Screw	M14604

SP

17.0

MS951910

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part number	Description	batch
1	MS9519-10	Bolt	100296

8/4/7

SP

(2x)

18.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble pedal as per Dwg D412-704-041

Tighten & Torque Bolts as per Dwg D412-704-041

JP 08/04/24 (2)

19.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

JP 08/04/24 (2)

20.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

21.0

AN960JD10L

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty	Part number	Description	batch
4	AN960JD10L	Washer	M104885

JP 08/04/24 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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QA: N/C Closed: _____ Date: _____

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Job Number:



Seq. #:

Machine Or Operation:

Description :

22.0

AN36A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty

Part number

Description

batch

2

AN3-6A

Bolt

M106662

AS 08/04/23 (x2)

23.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Nut

Batch:

M106883

AS 08/04/24 (x2)

24.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

AS 08/04/25 (x2)

25.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

PPR- 38148

AS 08/04/25 (x2)

26.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/04/29 (x2)

Job Completion



MF 08-04-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

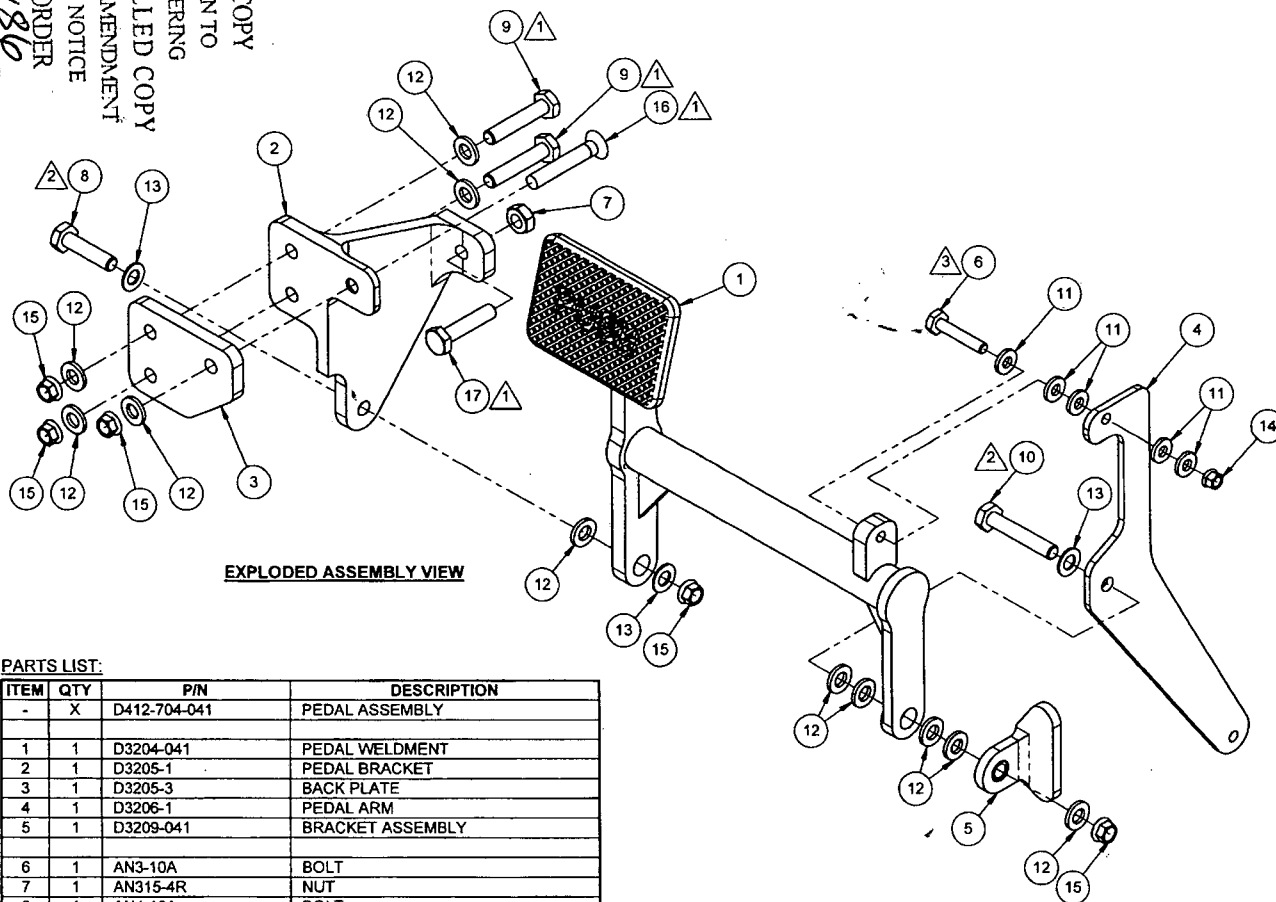
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 38180



EXPLODED ASSEMBLY VIEW

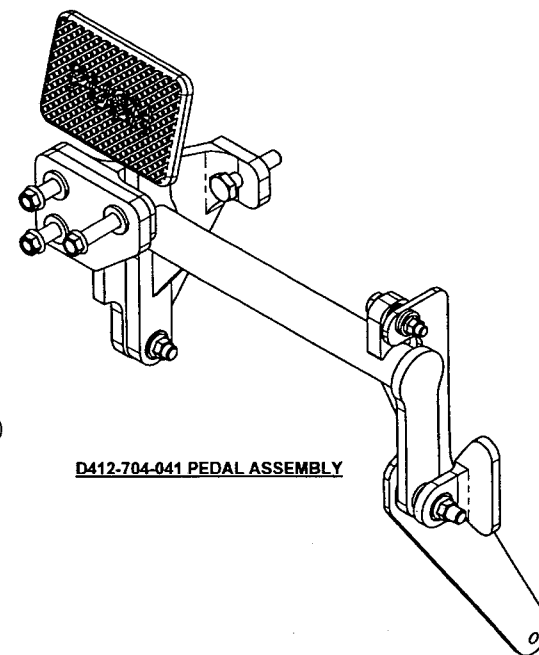
PARTS LIST:

ITEM	QTY	P/N	DESCRIPTION
-	X	D412-704-041	PEDAL ASSEMBLY
1	1	D3204-041	PEDAL WELDMENT
2	1	D3205-1	PEDAL BRACKET
3	1	D3205-3	BACK PLATE
4	1	D3206-1	PEDAL ARM
5	1	D3209-041	BRACKET ASSEMBLY
6	1	AN3-10A	BOLT
7	1	AN315-4R	NUT
8	1	AN4-10A	BOLT
9	2	AN4-12A	BOLT
10	1	AN4-13A	BOLT
11	5	AN960JD10	WASHER
12	11	AN960JD416	WASHER
13	3	AN960JD416L	WASHER
14	1	MS21042L3	NUT (OR MS21042-3)
15	5	MS21042L4	NUT (OR MS21042-4)
16	1	MS24694-S102	SCREW
17	1	MS9519-10	BOLT
N/A*	2	AN3-6A	BOLT
N/A*	4	AN960JD10L	WASHER
N/A*	2	MS21042L3	NUT (OR MS21042-3)

* SHIPPED LOOSE WITH -041 KIT (NOT PRE-ASSEMBLED AT DART)

NOTES:

- 1 INSTALL IDENTIFIED FASTENERS LOOSE (HAND TIGHTEN ONLY).
- 2 TIGHTEN IDENTIFIED FASTENERS UNTIL SNUG. ENSURE THAT PARTS CAN STILL ROTATE.
- 3 TORQUE IDENTIFIED FASTENERS TO 15-25 in-lbs (1.7-2.8 N-m).



D412-704-041 PEDAL ASSEMBLY

RELEASED

07.01.23

A	07.01.23	NEW ISSUE	DESCRIPTION
REV	DATE		
DESIGN	DRAWN BY		
C.B.	C.B.		
CHECKED	APPROVED	DRAWING NO.	REV. A
CE		D412-704-041	SHEET 1 OF 1
DATE		TITLE	SCALE
07.01.23		PEDAL ASSEMBLY	1:2
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